

Asap

Split

Dart Aerospace Ltd.

Date: Monday, 10/22/2007 3:41:39 PM
 per Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAR
Job Number : 35281 <i>B-2</i>	
Estimate Number : 10390	
P.O. Number : <i>N/A</i>	Part Number : D3197041
This Issue : 10/22/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3197 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30655	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>8</i> Um: Each
Comment : Est Rev: A New Issue 05-11-08 JLM Est Rev: B As per Rev B 06-03-10 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M7075T73R1000	7075-T73 Round Bar 1" OD
-----	---------------	--------------------------



Comment: Qty.: 2.5410 f(s)/Unit Total: 30.4920 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000)
 Identify for D3197-1
 Batch: ~~1770007~~ *106070 20 01/10/27*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 29.125" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Face ends to lenght per dwg D3197
 2-Machine D3197-1 as per Folio FA340 and Dwg D3197
 3-Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.10.30

SA 07.10.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LATHE CONV

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Chamfer as per Dwg D3197

SA 07.11.19

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

CP 07-11-19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

YJ

07-11-20

(X8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105642

BR

07-11-21

(8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

07/11/21

(8X)

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2690-5

Lanyard

B35308 x20 B30611 x4

JS 07/11/21

(X8)

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3242-1

TAG

B30665 x(2) B3531 x(20) x14

JS 07/11/21 (X8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 AN960JD10

Washer B105792

AS 07/11/21 (x8)

13.0

D34893200

PIP PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3489-3-200

Pip Pin B26207

AS 07/11/21 (x8)

14.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3) M104625

AS 07/11/21 (x8)

15.0

MS27039124

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-24 Screw

M100274

AS 07/11/21 (x8)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3197-041 as per Dwg D3197

MF 07-11-24 (x8)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 07/11/26 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11- 23	16.	lanyard hooks kept coming out, resqueezed all of them 5 scrap	<u>AD</u> 6/5/26	Resqueezed all of them scrap the nonconforming parts (85)	MF 07-11- 26	<u>AD</u> 07/11/26	<u>AD</u> 07/11/26	<u>AD</u> 07/11/26
		D2690-5, # B 30611. R.C. malleable parts						

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 247 6/11/26 AS 07/11/26

(8)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/11/26

Job Completion



U 07-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

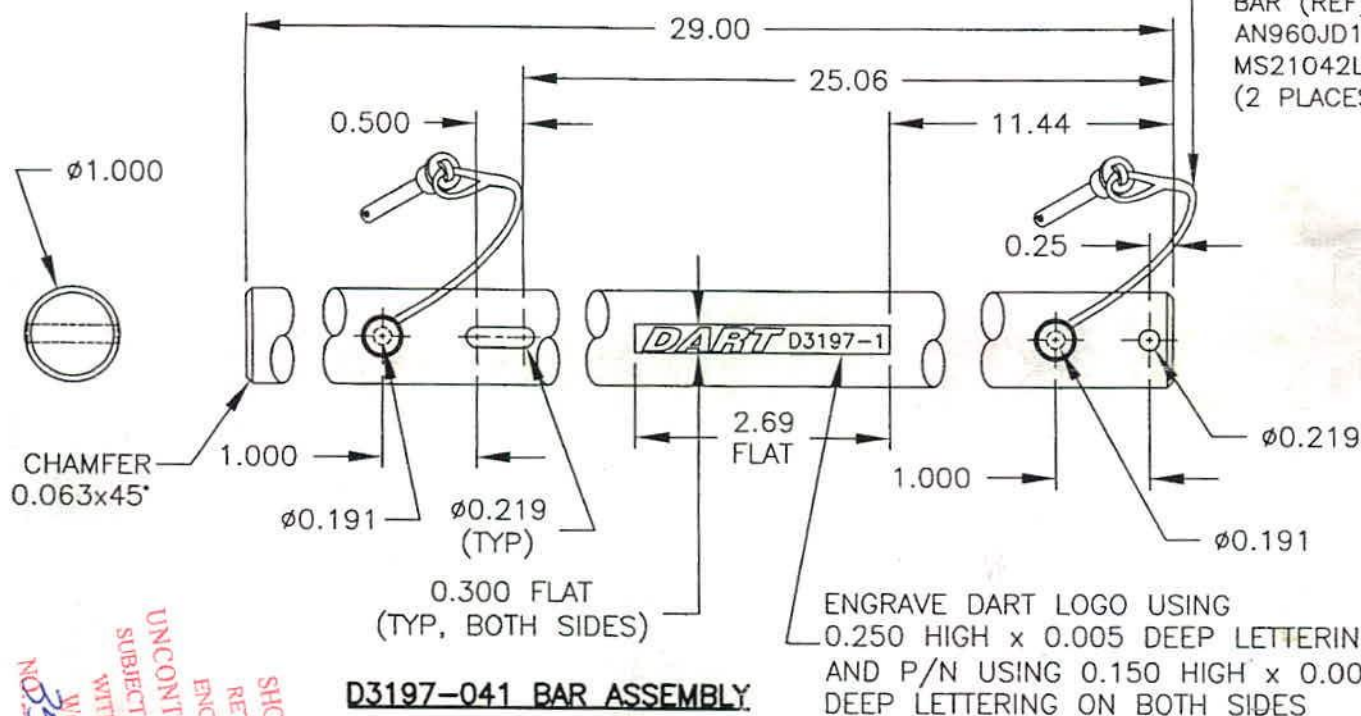
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

DART

- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)



D3197-041 BAR ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35281

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
		NEW ISSUE		
		CHG PIP PIN; ADD D3242-1 TAG		

